

ABSTRACT OF THE DISCLOSURE

An endless loop belt conveyor system that is free of rollers is produced from a roller conveyor or a powered endless belt roller conveyor using a conversion kit. The conversion kit includes at least one endless loop belt conveyor guide; and at least two conveyor guide-mounts. In addition, the conversion kit may include a motor driven roller section and an idler roller section both designed to be dropped in at the head portion or at the tail portion of a frame. The resulting converted conveyor system, and also the method of removing and replacing roller conveyors to convert the conveyor system to an endless belt conveyor that is free of rollers is taught.